

A1 .3125 W.058

Work Order ID 68946

Tuesday, April 26, 2011 10:41:42 AM



Page 1

Item ID: D3275-1

Accept



Setup Start



Revision ID:

Item Name: Crossbolt Spacer

Stop



Start Date: 4/26/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11/04/26 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3275	Rev A1

100



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

Memo

1-Turn as per Folio FA469 and Dwg D3275

0.00

0.00

0.00

0.00

0.00

0.00

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

120



QC8- Inspect parts - second check

QC

Quality Control

W/5/16

W/5/16

B.A 11/05/05

72 ♂

72 ♂

72 ♂

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68946

Tuesday, April 26, 2011 10:41:42 AM



Page 2

Item ID: D3275-1

Accept



Setup

Start



Revision ID:

Item Name: Crossbolt Spacer

Stop



Start Date: 4/26/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

STOCK IN SKIDTUBE CELL

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 10:41:48 AM

Page 1

Work Order ID: 68946



Parent Item: D3275-1



Parent Item Name: Crossbolt Spacer

Start Date: 4/26/2011

Required Date: 5/17/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A□04.10.19□New issue□KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No			100	f	191.6390	0.2666	16.83789			

ALUM TUBE .3125 x .058w



Location	Loc Qty	Loc Code
MAT013	191.639	
116793	1.667	
116939	93.972	
117400	96	

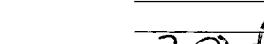


SD 105/15





20 P+



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	C8946
Description: Crossbolt Spacer	Part Number:	D3275-1
Inspection Dwg: D3275 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SJ</u>	Audited by:	<u>J.A</u>	Prototype Approval:	N/A
Date:	<u>11/5/05</u>	Date:	<u>11/5/05</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.19	New Issue	KJ/JLM	
B	06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM	
c	09.05.04	Ø0.197 dimension removed	KJ/DD	<i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. A D3275 SHEET 1 OF 1
DATE		TITLE SCALE 04.03.10 CROSS BOLT SPACER 1:1
A	04.03.10	NEW ISSUE
A1	04.10.19	CHANGE MAT'L SPEC

RELEASED
04.06.22

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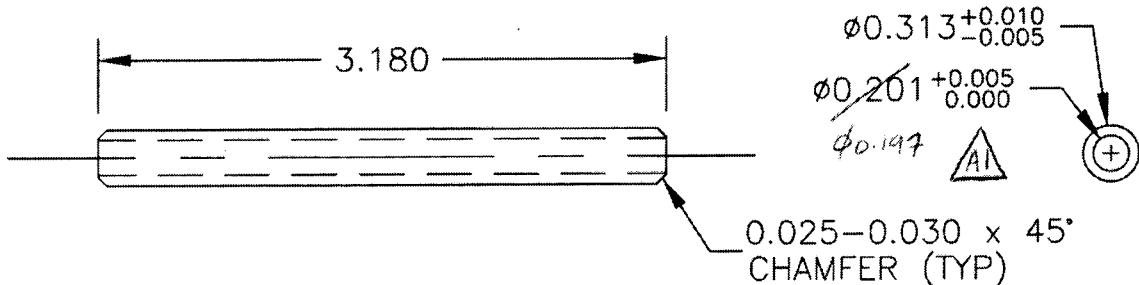
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. CG944

PP11-04-26



D3275-1 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6R) M6061T6T0.313W.058 A1
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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